

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025055**Date Inspected:** 21-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2100**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector,Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

OBG –Bay 14

This QA Inspector observed the following work in progress,

Shielded Metal Arc Welding (SMAW)

Weld joint- 003/ 004, Located on Edge plate to Drop plate in Segment 14W –OBW 14A. Welder is identified as 070007. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-P-2113 –FCM-1.

Weld joint- 069, Located on Floor beam, PP 125.5 in Segment 14W –SEG 3020X. Welder is identified as 067588.

ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U4B-FCM-1.

Repair welding of Weld joint- 011, Located on Deck plate in Segment 14W –SEG 3020AV. Welder is identified as 045196. ZPMC Quality Control Inspector (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-1G (1F) – Repair.

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Magnetic Particle Testing (MT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification no. 9569

This QA inspector performed (MT) of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated a TL 6028 MT report for this date. The member is identified as OBG Lift 14W components. The weld designations reviewed are as follows:

SEG 3020 AY – Jt. nos -117 ~140

SEG 3020Q- Jt. nos -040, 042,045,048,017, 018, 020,022, 024~026,186,184,037,038

Ultrasonic Testing (UT)

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 09546

This QA inspector performed UT of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report (TL 6027) for this date. The member is identified as OBG Lift 14W Components. The weld designation reviewed as follows:

SEG3020W-Jt. nos -018,193~196,009,012,015

SEG3020 M-Jt. nos -035,204~206

SEG 3020 T-Jt. nos -297,283,278,278

SEG3020R-Jt. nos -006,009,012,015,020

SEG3020P-Jt. nos -020,027,032,035

SEG3020E-Jt. no. -025

For further information's, see the pictures below:

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

No relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (15000422372), who represents the Office of Structural Materials for your project.

Inspected By: Baskar, Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer